DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-020057 Address: 333 Burma Road **Date Inspected:** 18-Mar-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Liu Hua Jie, Lu Li Qing, Geng Wc WI Present: Yes No

Inspected CWI report: Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No

Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BW, Deck plate (DP3057A) to Deck plate (DP3058A).

FCAW welding of weld joint SEG3005*-002; located on assembly, Bay 14, 12BW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12AE, CA6501C.

During Random Visual in process Inspection, this QA inspector observed Crack like Indication at temporary attachment area on side plate (SP3016A) of Corner assembly (CA6501C). This QA inspector confirmed the indication with Magnetic Particle Inspection (MT) & also informed ZPMC QC "Geng Wei". The attached photographs provide additional detail.

Assembly, Bay 14, 12AE, CA6501C.

FCAW welding of weld joint CA6501C-023, 027, 031; located on assembly, Bay 14, 12AE. Welder is identified as 044795; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by

Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

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Assembly, Bay 14, 12AE, CA3001.

FCAW welding of weld joint CA3001-003; located on assembly, Bay 14, 12AE. Welder is identified as 058551, 044774; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-T-2231-TC-U4B-F, 2) WPS-B-T-2231-TC-U4C-F.

Assembly, Bay 14, 11DE, SEG072.

SMAW welding of weld joint SSD18-PP106-0129; located on assembly, Bay 14, 11DE. Welder is identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4B-FCM-1.

Assembly, Bay 14, 12CE.

During Random Visual in process Inspection, this QA inspector observed fit-up of Edge plate EP3003A of Corner Assembly CA3004E. The attached photographs provide additional detail.

Training for Phased Array Ultrasonic Testing.

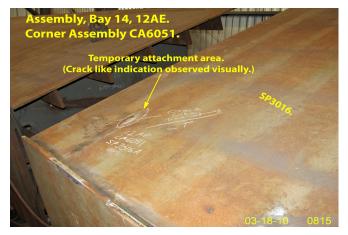
This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.









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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar, Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer